

Date: Friday, 01/05/2009 11:20:10 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE RIM
Job Number	: 47653		
Estimate Number	: 11334		
P.O. Number	:	Part Number	: D333019
This Issue	: 01/05/2009 S.O. No. :	Drawing Number	: D3330 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: D
Previous Run	: 45330	Material	:
Written By	:	Due Date	: 18/05/2009 Qty: 10 Um: Each
Checked & Approved By	: <u>JUP 09.05.01</u>		
Comment	: Est: A 05.01.13 New issue KJ/JLM est B 07.05.14 rev C dwg EC Est C 07.12.12 Rev D dwg EC verified by:DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1018TR13125W109	ROUND TUBING 1.3125 x .109w
	Comment: Qty.: 0.0525 f(s)/Unit Total: 0.5250 f(s) 1010-1025 Steel Bar Material: AISI 1010-1025 1" Schedule 80 B tubing (M1025TRS80) Identify for D3330-19 Batch <u>M16889</u> : <u>09.05.07</u>	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
	Comment: HARDINGE CNC LATHE SMALL Turn as per Folio FA491 and Dwg D3330 Deburr <u>09.05.07</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>09.05.08</u> (10)	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK <u>09/05/08</u> (10)	
5.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>Cen</u> <u>9/5/8</u> <u>50</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 01/05/2009 11:20:11 AM  
User: • Linda Lacelle

## Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services

**Drawing Name:** HANDLE RIM

**Job Number:** 47653

**Part Number:** D333019

Job Number:



**Seq. #:**

**Machine Or Operation:**

**Description :**

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/08  
MF

**Comment:** FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

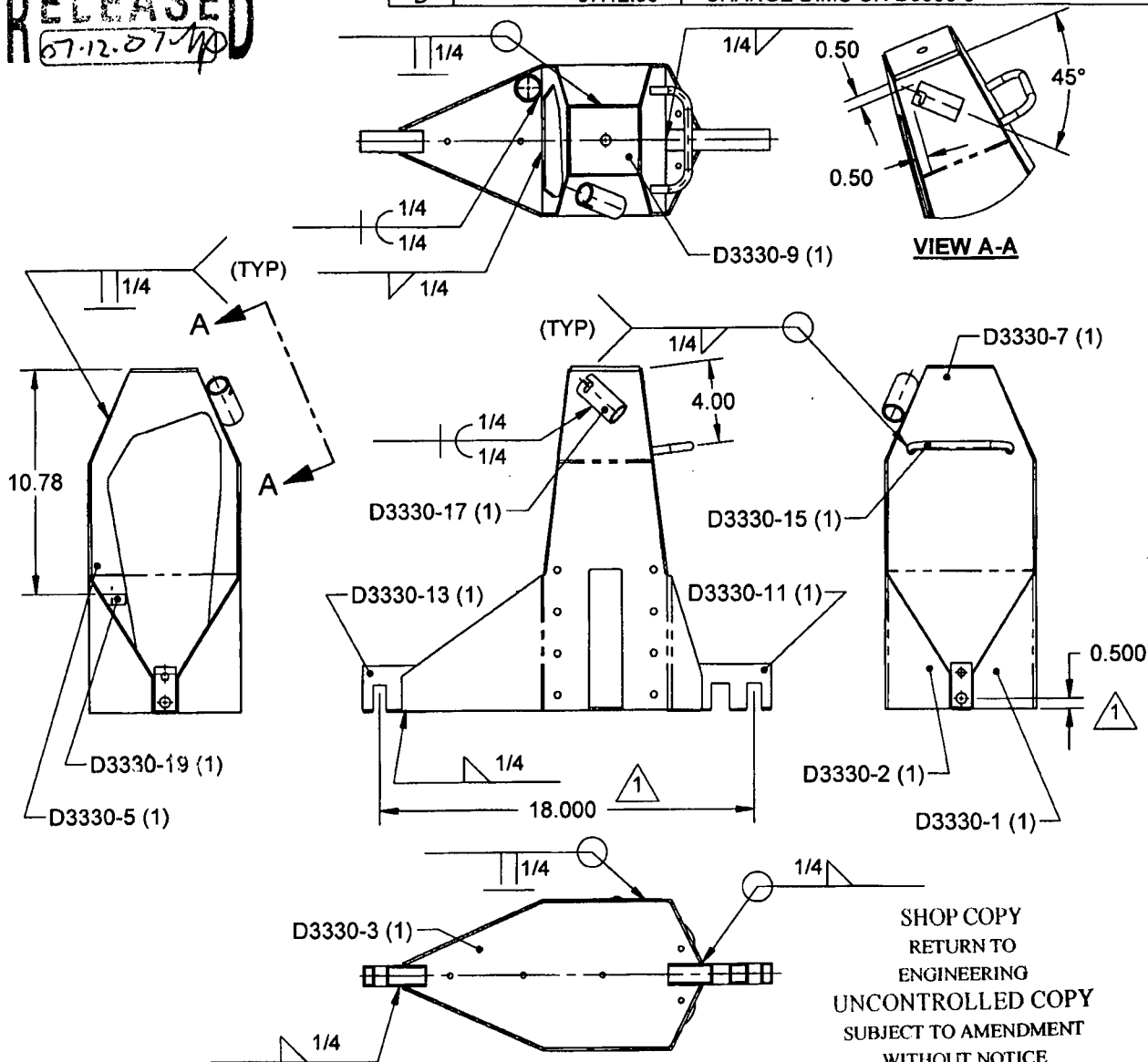
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART****RELEASED**  
07-12-07

DESIGN <i>13</i>	DRAWN BY <i>DC</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>13</i>	APPROVED <i>W</i>	DRAWING NO. <b>D3330</b>	REV. D SHEET 1 OF 9
DATE <b>07.12.06</b>	TITLE <b>FRAME WELDMENT</b>	SCALE 1:8	
REV	DATE	DESCRIPTION	
A	04.12.16	NEW ISSUE	
B	05.02.26	RE-DESIGN	
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125	
D	07.12.06	CHANGE DIMS ON D3330-9	

**D3330-041 FRAME WELDMENT****NOTES:**

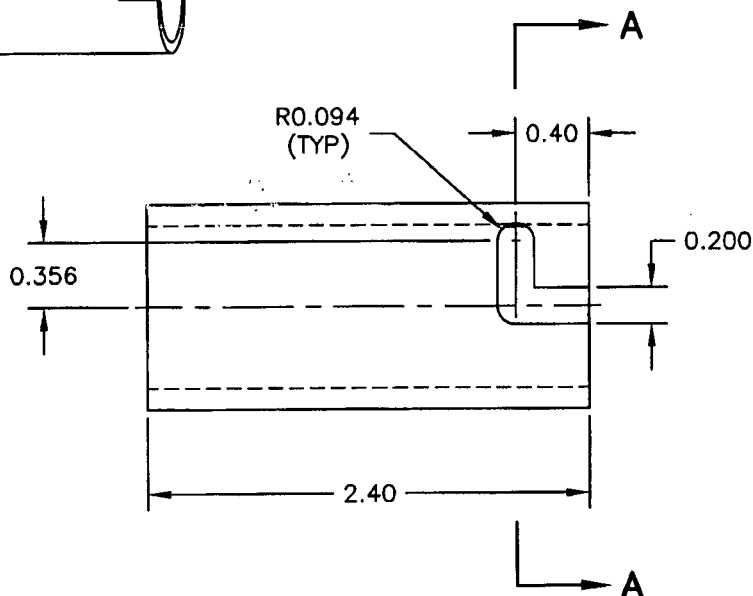
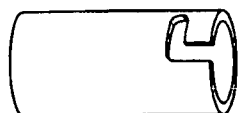
- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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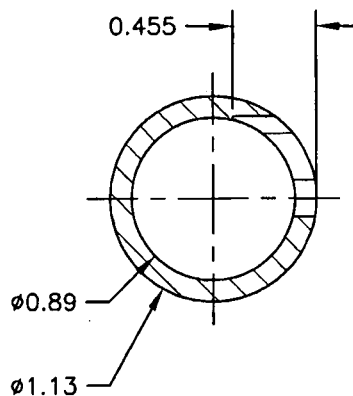
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DESIGN 3	DRAWN BY DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 3	APPROVED MP	DRAWING NO. D3330	REV. D SHEET 8 OF 9
DATE 07.12.06	TITLE FRAME WELDMENT		SCALE 1:1

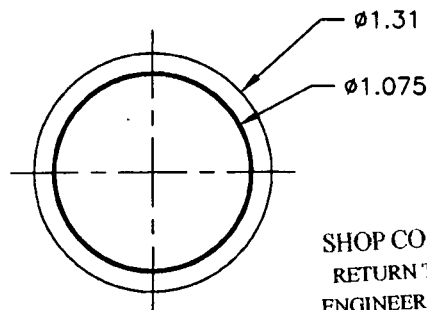
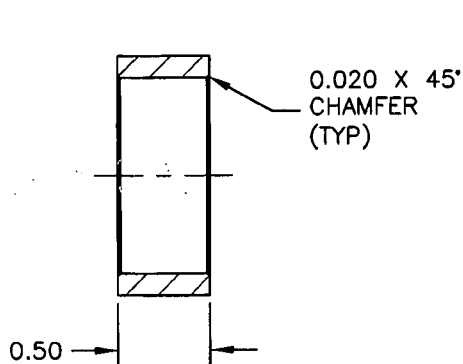


RELEASED  
07.12.07 MP



**SECTION A-A**

**D3330-17 HANDLE SOCKET**



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 47653

**D3330-19 HANDLE RIM**

**NOTES:**

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097  
(REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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